

Work Order ID 68102

Wednesday, April 06, 2011 2:26:24 PM



Page 1

Item ID: D2652

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 4/6/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-04-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2652

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA252 & DWG D2652 FOLIO
REV: *A* DWG REV: *A* 2-DEBURR AS REQUIRED

1106113

200 *φ*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1106113

200 *φ*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ant 11/06/14

200 *φ*

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

[illegible]

Wednesday, April 06, 2011 2:26:24 PM

Accept



Setup Start



Stop

██████████

[illegible]**Cust Item ID:**

Start Date: 4/6/2011 **Start Qty:** 200.00

Required Date: 4/13/2011 **Req'd Qty:** 200.00

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept Qty

Reject Qty

Reject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: 017

0.00

[illegible]

Packaging

Memo

0,00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/14

MA

11-06-12

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 2:26:33 PM

Page 1

Work Order ID: 68102



Parent Item: D2652



Parent Item Name: Bushing


Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:B 02.06.13 Now machined in house. NG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R0.500  303 Round Bar 0.500" | | Purchased | No | | | 100 | f | 72.5000 | 0.055 | 11.57895 | | | |



SA 11/6/13

Location

Loc Qty

Loc Code

MAT028

72.5

117143

72.5

12 ft

10 ft

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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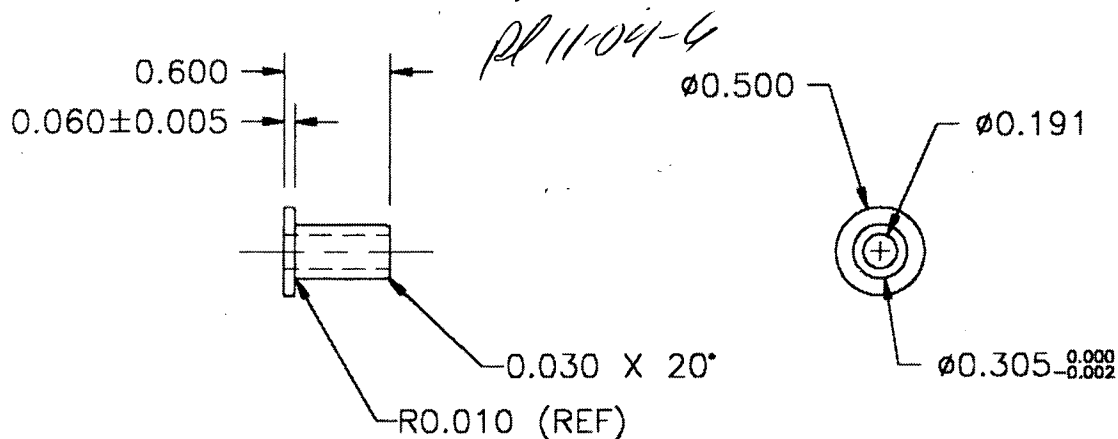
NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2652 | REV. A SHEET 1 OF 1 |
| DATE 97:03:25 | | TITLE BUSHING | SCALE 1:1 |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48102

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries